

Date: Tuesday, 7/1/2008 2:33:50 PM
 User: Kim Johnston

Process Sheet

ASA P.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HEAD REST
 Job Number : 40186
 Estimate Number : 10738
 P.O. Number :
 This Issue : 7/1/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 38967
 Written By :
 Checked & Approved By : 08.07.01
 Comment : Est: B04.10.05 Revised Step 5 with headrest indentification K
 J/JLM

Part Number : D3303041
 Drawing Number : D3303 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 7/28/2008 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3303043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET ASSEMBLY

Pick:

Qty	Part Number	Description
1	D3303-043	Bracket Assembly

Batch
B38969 x 2
40906 2

2.0 D33051 Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

FOAM CUSHION

Pick:

Qty	Part Number	Description	Batch
1	D3305-1	Cushion	<u>B 29945</u>

3.0 D3306041 Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

COVER ASSEMBLY

Pick:

Qty	Part Number	Description
1	D3306-041	Cover Assembly

Batch
B38970 29946

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1501 or 8046 adhesive.

Identify as D3303-041

M102890

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:50 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 40186

Part Number: D3303041

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R 3M 1300/1300L Adhesive

Batch: 1102890

SB 08/08/14

2- Cover Head Rest with D3306-041 as per Dwg D3303

FF 08-08-14

5.0

QC5

INSPECT WORK TO CURRENT STEP



0808.14 (4)



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(LX)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock

Location: 188

8/8/14

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

Job Completion



U 08.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

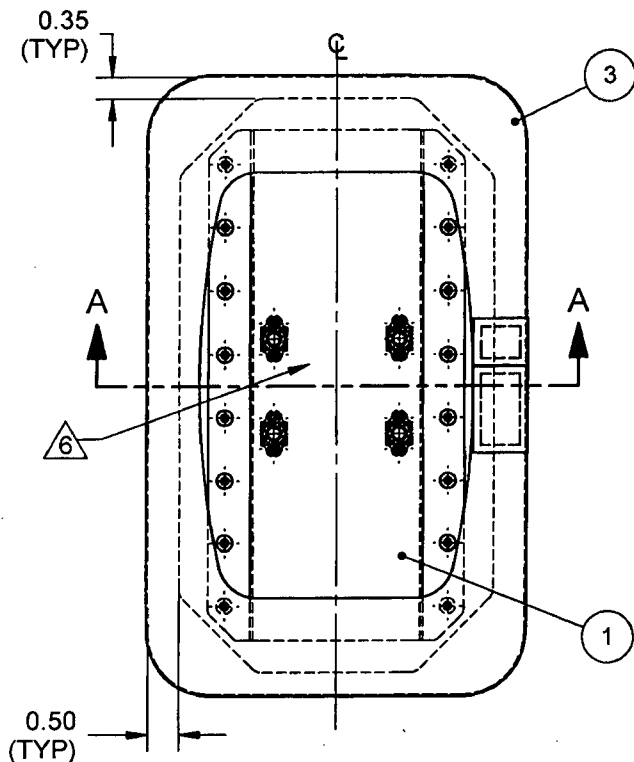
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

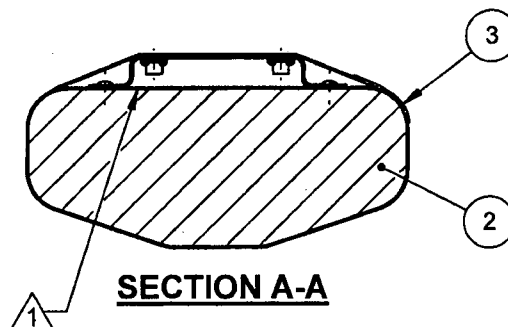
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303 REV. B SHEET 1 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE



RELEASED
dc 09.19



D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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NO. *40186*

NOTES:

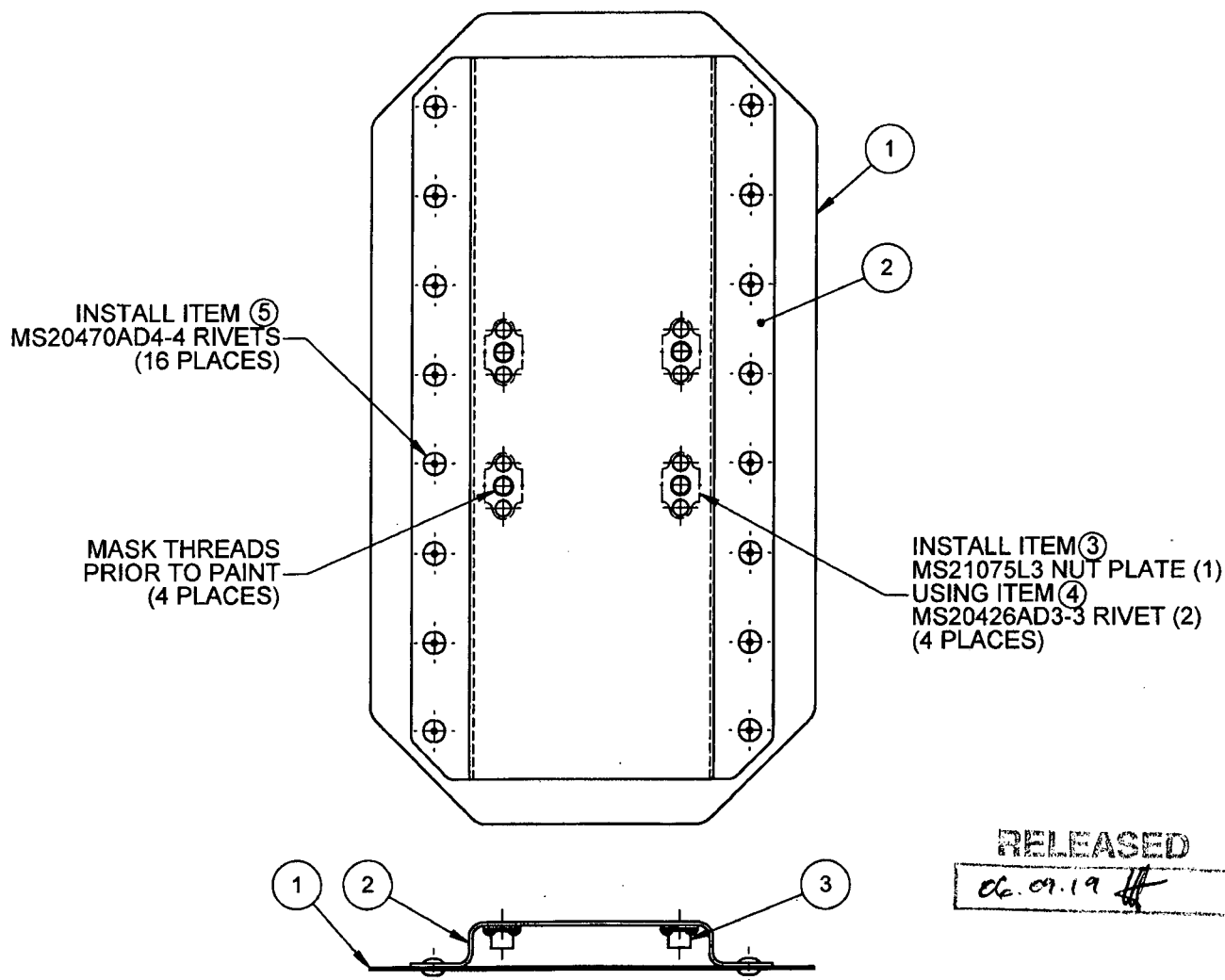
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACORDDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



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06.09.19 *[Signature]*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

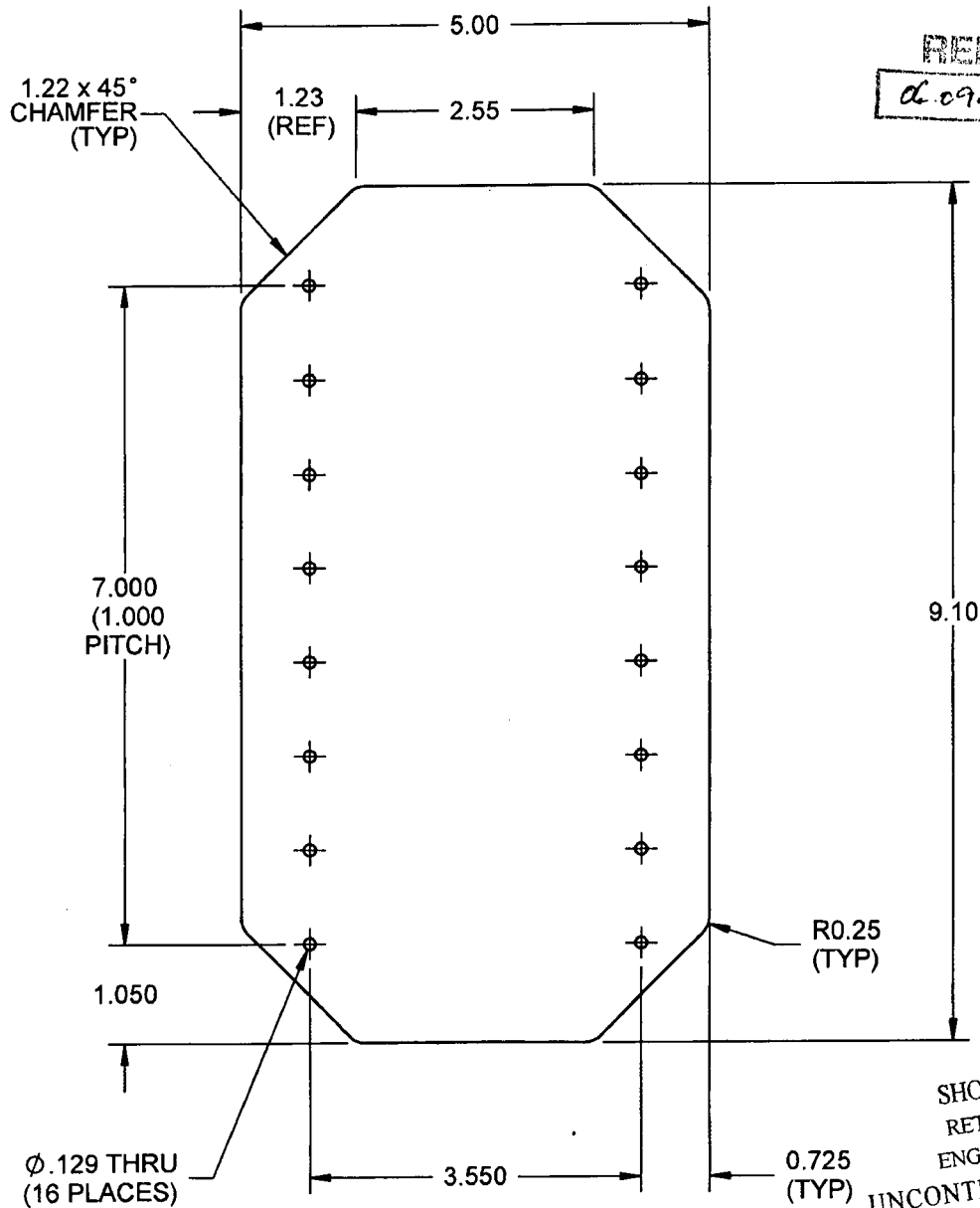
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

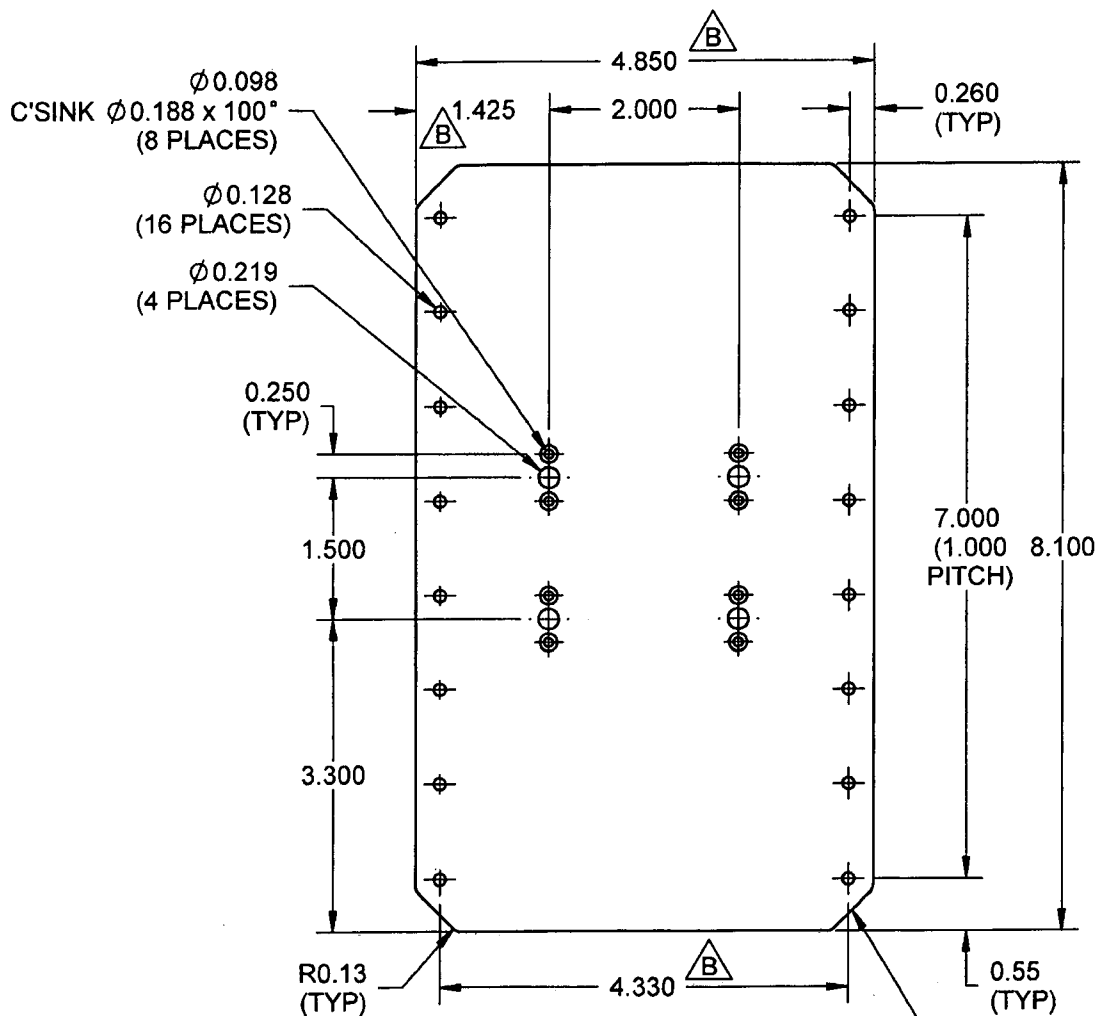
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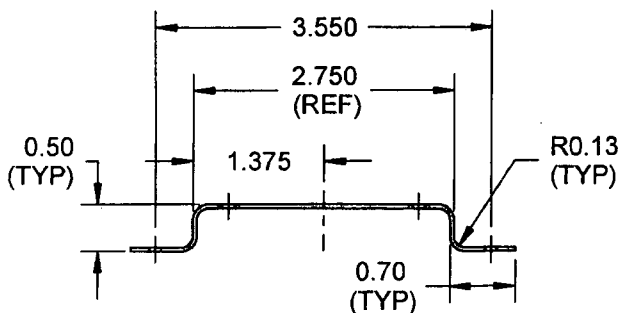
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D3303-3F BRACKET FLAT PATTERN



D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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06.09.19

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